

Amendments to the Specification

Please replace the paragraph on page 10, beginning line 13, with the following amended paragraph:

--The sides of the broach cutting teeth 21 that are allocated to the flanks 15, 16 of the work piece 8, which are to be produced, vary in design. The sides of the broach cutting teeth 21a to 21f that are allocated to a flank 15 - on the left in Fig. 3 - are pure guide flanks 26a to 26f. Over the full flank height, their course corresponds to the course of the flank 15 that is to be produced. ~~[[The]]~~ They do not possess a relief produced by grinding or a relief angle i.e., they are not designed as a relief surface as seen in Fig. 5, and are not relieved in position as seen in Fig. 5. The pitch a is in the range of 10 to 80  $\mu\text{m}$ . The guide edge 27a to 27f between the respective guide flank 26a to 26c and the machining surface 25 is a non-cutting edge 27a to 27f without cutting ability.--